

6061-T6 R.500"

## Work Order ID 96854

\*96854\*

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February-07-13 11:32:10 AM

Item ID: D2651-1 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

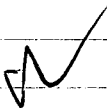
Item Name: Plug

Start Date: 2/07/13 Start Qty: 100.00 \*100\*

Required Date: 2/28/13 Req'd Qty: 100.00 \*100\*

Reference: Cust Item ID:

Customer:

Approvals: Process Plan:  Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2651	Rev B								
100		0.00							
*100*	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1- Turn as per Folio FA219 and Dwg D26512- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

13-02-10

100

0

13-02-10

100

0

D.A. 13/02/11

100

0

D.A.  
08  
08

**\*96854\***

February-07-13 11:32:10 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*100\***

**Cust Item ID:**

**\*100\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

\*140\*

HandFinish

## Memo

0.00

## Hand Finishing

White Gloss(Ref: 4.3.5.1) per OSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

## Memo

0.00

## Powder Coating

(Only larger section necessary) START TIME: 12:10 OVEN TEMPERATURE: 320° FINISH TIME: 12:40

### QC3- Inspect Part Finish

0.00

**\*160\***

QC

## Memo

0.00

### Quality Control

# Work Order ID 96854

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Item ID: D2651-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Plug  
 Start Date: 2/07/13 Start Qty: 100.00 \*100\* Cust Item ID:  
 Required Date: 2/28/13 Req'd Qty: 100.00 \*100\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
*170*									
Packaging	Memo	0.00				X 100			13/02/19
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							13/2/19
Quality Control									

13-02-19

# Picklist Print

February-07-13 11:32:09 AM

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Work Order ID: 96854

Parent Item: D2651-1

Start Date: 2/07/13

Required Date: 2/28/13

Parent Item Name: Plug

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: A02.04.15New Issue NG  
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	53.6860	0.0401	4.89210526		13-02-10	

Location	Loc Qty	Loc Code
MAT012	53.686	
114488	3.994	
123483	12	
124029	37.692	

4.8921

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	46859
<b>Description:</b> Plug		<b>Part Number:</b>	D2651-1
<b>Inspection Dwg:</b> D2651	<b>Rev:</b> B	<b>Page 1 of 1</b>	

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>SS</i>	Audited by:	<i>D.A.</i>	DA8 08 9-89	Prototype Approval:	N/A
Date:	13-02-10	Date:	13/02/11		Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	

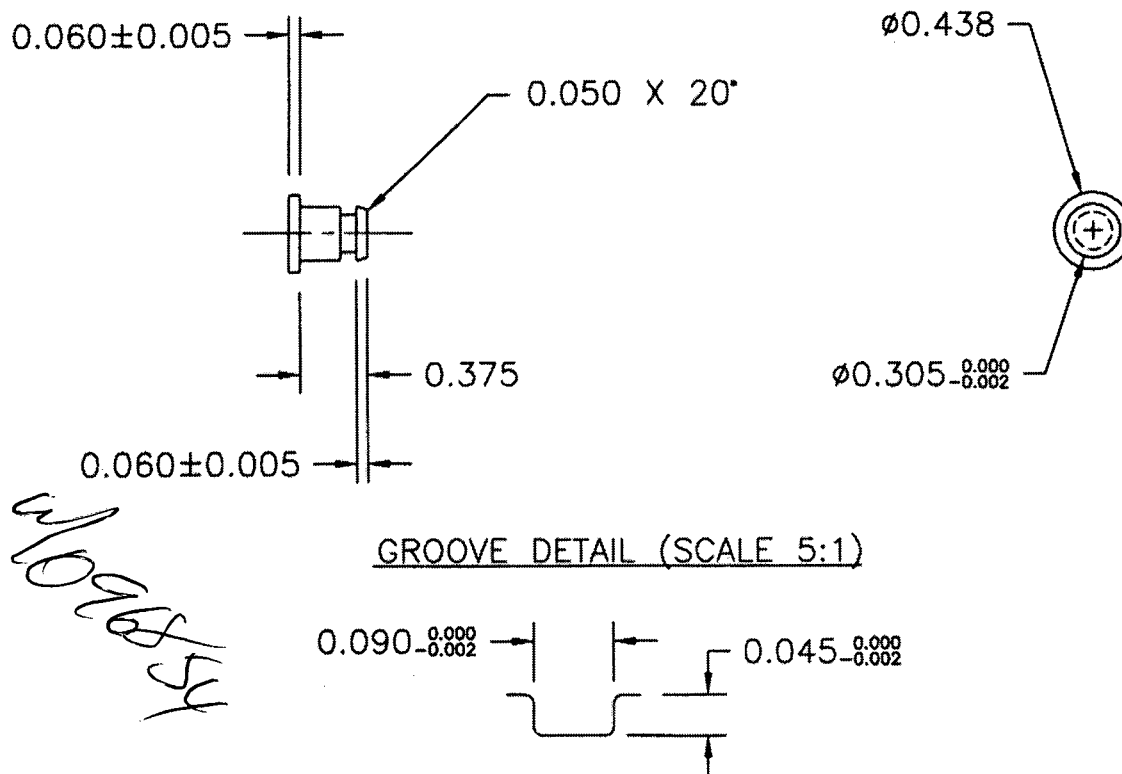


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED

03.12.19 *[Signature]*

### D2651-1 PLUG:



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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